

Date:  
User:Thursday, 04/12/2008 3:18:40 PM  
Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: REWORK D2972 TO D3864-1
Job Number	: 43921		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D38641
This Issue	: 04/12/2008 S.O. No. :	Drawing Number	: ECN08-573P
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 05/12/2008
Checked & Approved By	:	Qty:	70 Um: Each
Comment	:		

Additional Product

~~PRELIMINARY ISSUE~~08.12.06  
SEE RELEASED DWG

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

70 - 00 X D2972 B 42268

2.0	D2972	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)  
Bushing

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE → Cobra

RE-MACHINE PER DRWG D3864 REV.A  
PER ECN 08-573P

J.F. / 08/12/04

P105

69 pcs

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING

APPROVAL

08.12.06

08.12.05

for QSP019 (69)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3864-1 (DZ972) PAR #: N/A Fault Category: Eng Design NCR: Yes No DQA: D Date: 08/12/05  
 QA: N/C Closed: D Date: 08/12/06

NCR: 43921		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/05	3.0	Wall thickness not uniform, Difference of .012 due to set up in manual lathe as per work order specifications. Used Cobra for remaining work. R.C. New process for BULL NCR 08-115.	<i>[Signature]</i> 08/12/05	Qty 1 part Scrap.	<i>[Signature]</i> 08/12/05	<i>[Signature]</i> 08-12-05	<i>[Signature]</i> 08/12/05	<i>[Signature]</i> 08-12-05

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 3:18:40 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK D2972 TO D3864-1

Job Number: 43921

Part Number: D38641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

U 08.12.16 6B  
NOTE: QTY(1) USED FOR TESTING ~~PT~~ 08.12.10

ID & STK

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 JH

Job Completion

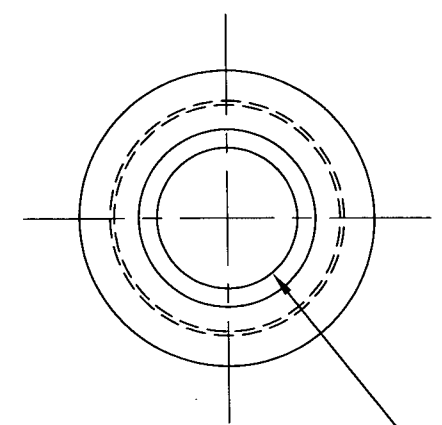
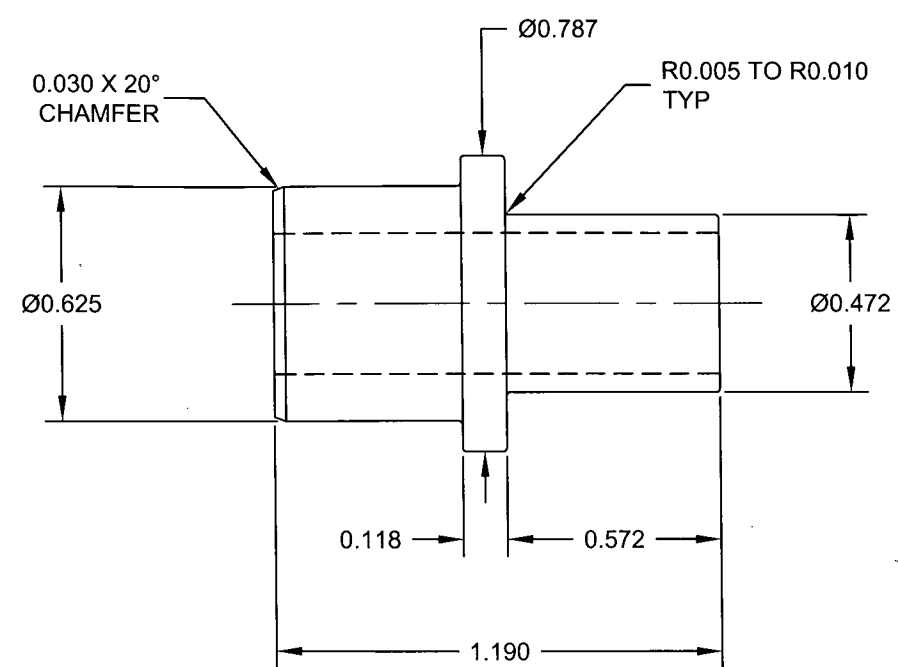


U 08.12.16

POSITIVE RECALL

EFFECTIVE 08.12.04 AUTH U

RELEASED PT DATE 08.12.16



Ø0.375  
Ø0.386  
PH  
08.12.04

**D3864-1 BUSHING**

**PRELIMINARY ISSUE**  
PH 08.12.04

- NOTES:**
- 1) MATERIAL: AISI 303 ROUND BAR  
(DART SPEC M303RX.XXX)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A

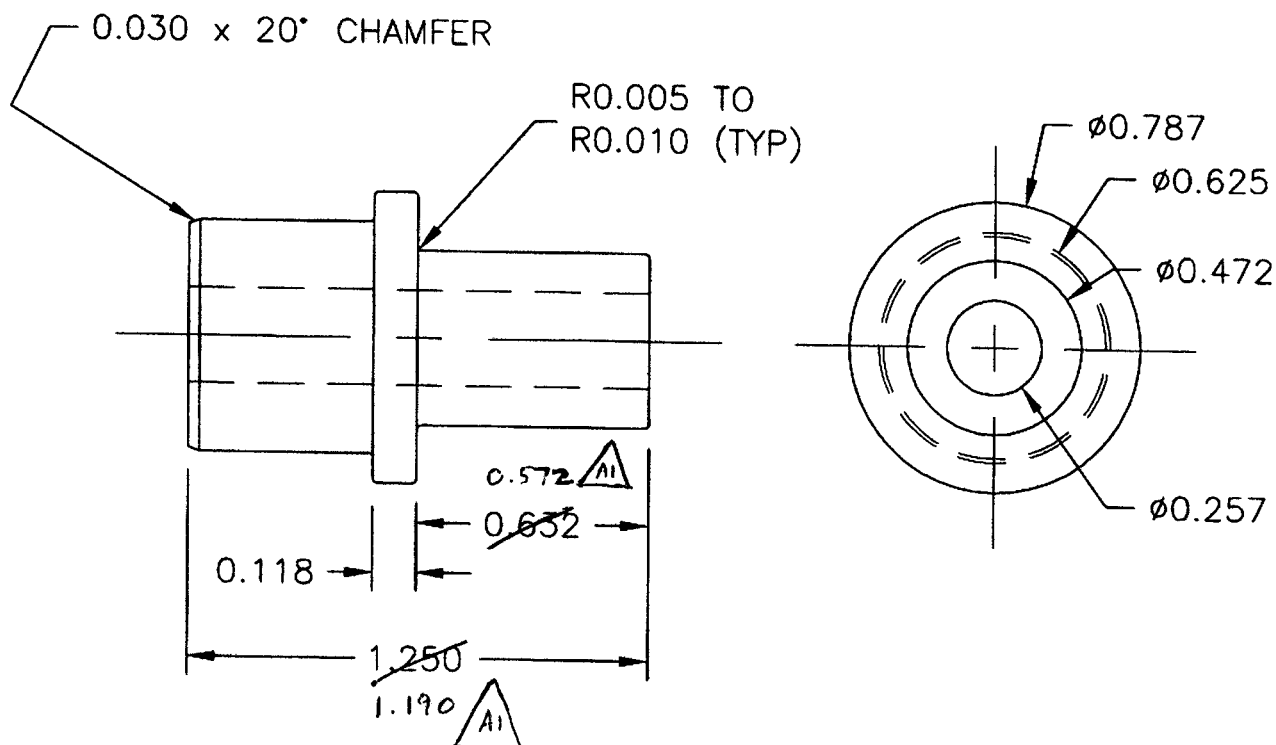
A	NEW ISSUE	PH	08.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		D3864	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	08.12.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2972	REV. A SHEET 1 OF 1
DATE 00.03.13		TITLE BUSHING	SCALE 2:1
A	00.03.13	NEW ISSUE	

RELEASED  
00.05.11



REFERENCE ONLY

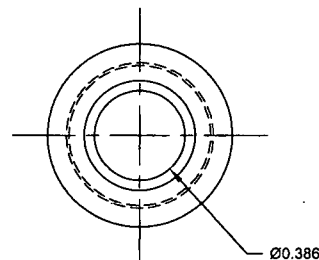
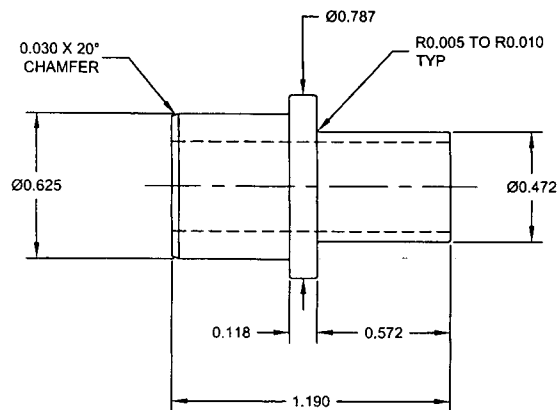
MATERIAL: AISI 303 STAINLESS STEEL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
RADIUS ALL INSIDE EDGES 0.005 TO 0.010  
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
ALL DIMENSIONS ARE IN INCHES

A1 01.03.12 REDUCE LENGTH OF BUSHING # CP

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# **D3864-1 BUSHING**

RELEASED  
08.12.04

U6 43921

## **NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR  
(DART SPEC M303RX.XXX)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 LBS

A	NEW ISSUE	PH	08.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3864	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NTS
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